

S-7010.A1

TYPE : Cellulosic

AWS A5.5 / ASME SFA5.5 E7010-A1
ISO 2560-A - E42 0 Mo C 1 5

Applications

S-7010.A1 can be used for welding of 0.5%Mo steel pipe, high pressure boilers, drums, thin steel plate for buildings and oil pipes.

Characteristics on Usage

S-7010.A1 is a high cellulose type electrode which contains 0.5%Mo in its coating. X-ray performance and mechanical properties are extremely good.

Notes on Usage

- ① Preheat at 100~200°C(212~392°F) and postheat at 620~680°C(1148~1256°F).
- ② Dry the electrodes at 70~100°C(158~212°F) for 30~60 minutes before use.

Welding Position



5G Up/Down

(PE.PG)

Current

DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Mo
0.09	0.12	0.32	0.015	0.015	0.61

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Heat Treatment
552 (80,000)	575 (83,400)	28.4	620°C(1148°F) × 1hr. S.R

Approval

ABS, LR

I Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	350 (14)	350 (14)	350 (14)
F	55~80	80~120	120~160	160~210
V-up,OH	50~70	70~110	110~150	-